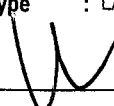
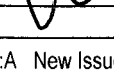


24-14/09

Dart Aerospace Ltd.

Date: Thursday, 06/09/2007 3:11:05 PM
User: Linda Lacelle













Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TAIL LIGHT FAIRING
Job Number	: 34451		
Estimate Number	: 12418		
P.O. Number	: N/A	Part Number	: D3484042
This Issue	: 06/09/2007 S.O. No. : N/A	Drawing Number	: D3484 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: D
Previous Run	: 30764	Material	: N/A
Written By	: 	Due Date	: 13/09/2007 Qty: 2 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev:A New Issue 06-05-23 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3484042	TAIL LIGHT FAIRING, RH
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) BASE, RH Batch: 30764 11 07-09-06	
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
	Comment: LARGE FABRICATION RESOURCE 1 1-Buff & Smooth Welds to mating surfaces 06/09/07 (2)	
3.0	QC5	INSPECT WORK TO CURRENT STEP
		
	Comment: INSPECT WORK TO CURRENT STEP 07-09-07 (2)	
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 07-09-10 (2)	
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION FF 07-09-10 2	
6.0	MS20426AD33	Rivet
		
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s) Rivet Batch: 111563 FF 07-09-10 2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 01/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/09/2007 3:11:05 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 34451

Part Number: D3484042

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

ANCHOR NUT

Batch: 1719633

FF 07-09-10

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

07-09-11 (2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/11 (2)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M1105068

07-09-11 (2)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/09/11 (2)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N: D412-750-142 B/N: BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

07-09-11 (2)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-09-11 (2)

Job Completion



07-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

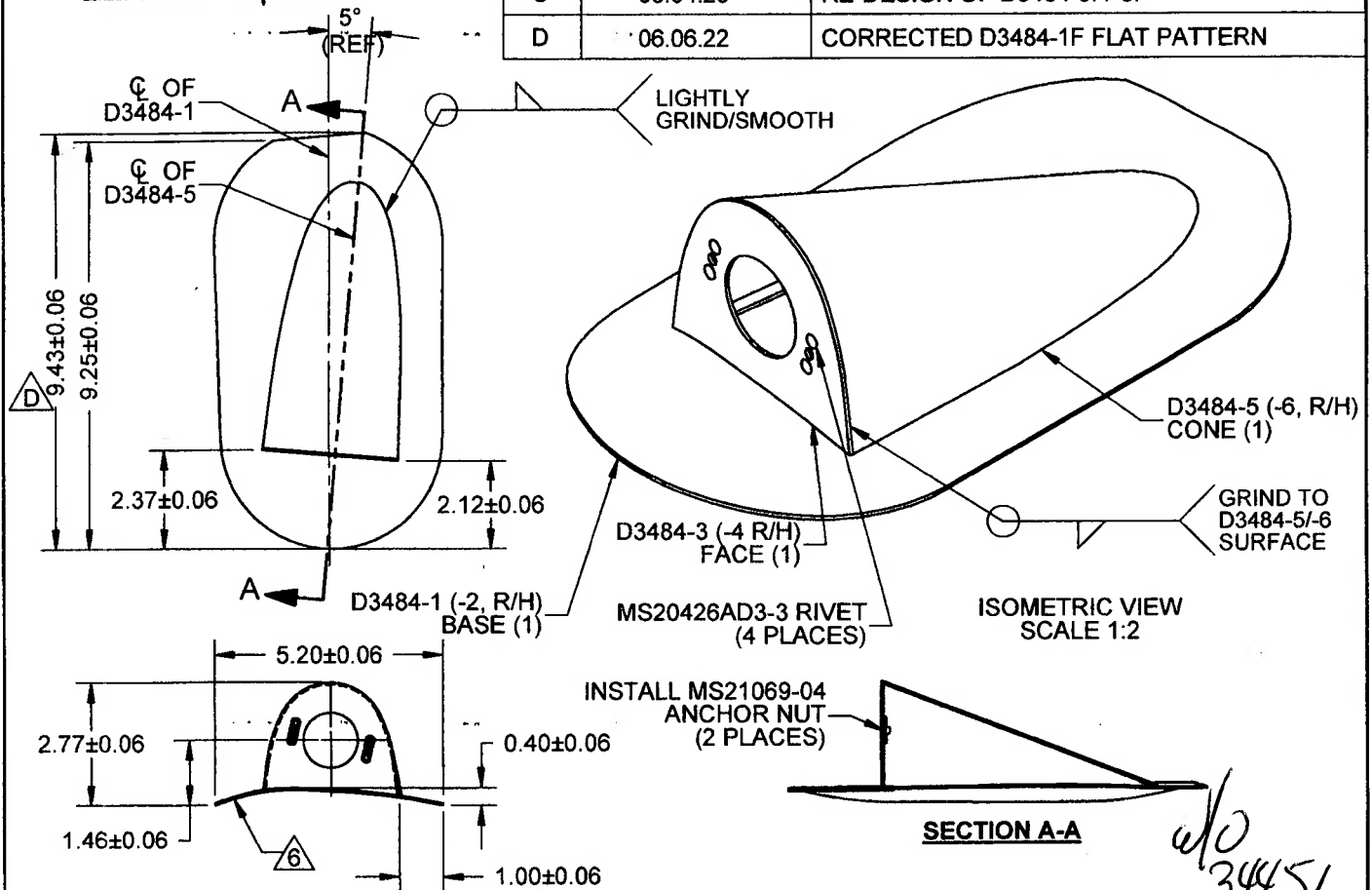
NOTE: Date & initial all entries

DART

RELEASED

06.08.17

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3484	REV. D SHEET 1 OF 4
DATE	06.06.22	TITLE TAIL LIGHT FAIRING	SCALE 1:4
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	
D	06.06.22	CORRECTED D3484-1F FLAT PATTERN	

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD.,
P/N D412-750-141/-142 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE
PDA06-13"

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H)
	1	D3484-2	BASE (R/H)
1		D3484-3	FACE (L/H)
	1	D3484-4	FACE (R/H)
1		D3484-5	CONE (L/H)
	1	D3484-6	CONE (R/H)
4	4	MS20426AD3-3	RIVET
2	2	MS21069-04	ANCHOR NUT

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Date: Thursday, 06/09/2007 9:48:07 AM

User: Linda Lacelle

Bill of Manufacturing

Part Number : D412750142
Drawing Name : TAIL LIGHT FAIRING

Revision : A
Default Qty. : 1

Seq #	Item	Description	Qty	U/M	Unit Cost	BOM Cost
1	DC	Photocopy bluefile & type labels per PPP	0.00	Hours	43.00	0.00
2	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	37.00	0.00
3	D3484042	TAIL LIGHT FAIRING, RH	1.00	Each	0.00	0.00
4	AN33A	Bolt	10.00	Each	0.31	3.12
5	AN960JD10	Washer	10.00	Each	0.03	0.33
6	QC4	INSPECT 100% KITS FOR COMPLETENESS	0.00	Hours	43.00	0.00
7	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	37.00	0.00
8	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
Total BOM Cost						3.45